

# Work Order ID 92987

Tuesday, November 13, 2012 7:58:40 AM

**\*92987\***

Ship Nov. 13  
06th soon

Page 1

Item ID: DSI 9594-011

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Fwd Ground Handling Spacer

Start Date: 11/13/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 11/22/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: *MF*

Date: *12-11-23*

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

DSI 9594

A

100

**\*100\***

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP DSI 9594-011 CHG001

0.00

0.00

*12-11-14*

*for MJS 12-11-13*

110

**\*110\***

Packaging

Packaging

Pick Kit

Memo

0.00

0.00

*12-11-13*

120

**\*120\***

QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.00

*12-11-14*

**Work Order ID 92987****\*92987\***

Page 2

Tuesday, November 13, 2012 7:58:40 AM

Item ID: DSI 9594-011

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Fwd Ground Handling Spacer

Stop

**\*NS2\***

Start Date: 11/13/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 11/22/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00

**\*130\***

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP DSI 9594-011

Location: 032

sf sk 12/11/13

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

12/11/15 dg

W12-11-14

# Picklist Print

Tuesday, November 13, 2012 7:58:40 AM

Page 1

Work Order ID: 92987

Parent Item: DSI 9594-011

Parent Item Name: Fwd Ground Handling Spacer

Start Date: 11/13/2012

Required Date: 11/22/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.02.27 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<b>D2S79</b> Crossbolt Spacer		Manufactured	No			110	Each	135.0000					

## Location

## Loc Qty

## Loc Code

LG		90
	92473	90
LG001		45
	62400	22
	70761	3
	72199	1
	72672	7
	78371	12

Sm3

4x

8012-11-13

**DART SERVICE INSTRUCTION**

TO AMEND INSTALLATION INSTRUCTIONS IIN-D119-646 REV. B,  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D119-646 REV. 1 OR EARLIER,  
REF. FAA STC SR02024SE

**1.0 PURPOSE**

The purpose of this DSI is to provide instructions for customers to add fwd ground handling holes to their D119-646-XXX skid tubes using the DSI 9594-011 Kit. One kit modifies 2 skid tubes.

**2.0 PROCEDURE**

Modify the skid tubes as follows:

- 2.1 Rotate the D3407-041 Tow Ring to the vertical position as necessary.
- 2.2 Mark holes in the center ridge as shown in Figure 1. Drill through skid tube with  $\varnothing$  0.500" (12.7 mm drill), and countersunk to  $\varnothing$  0.650 x 100°, two places per side.
- 2.3 Deburr holes. Touch up affected area with chemical film material (Alodine 1200 or 1201) per MIL-C-5541.
- 2.4 Bond D2579 spacers into the  $\varnothing$  0.500 holes center in the skid tube using Magnobond 6398. Grind flush prior painting as shown in Figure 1.
- 2.5 Apply one coat of MIL-P-85582 or MIL-P-2337 primer and 2-3 coats of MIL-C-83285 polyurethane coat to match original finish.
- 2.6 Repeat steps 2.1 to 2.5 for opposite skid tube.

**3.0 PART LIST**

Qty -011	PART NUMBER	DESCRIPTION
X	DSI 9594-011	FWD GROUND HANDLING SPACER KIT
4	D2579	CROSS BOLT SPACER

**4.0 WEIGHT AND BALANCE**

This modification has negligible effect on weight and balance.

A	NEW ISSUE	RF	12.02.03
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9594	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FWD GROUND HANDLING SPACER KIT	NTS
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